

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1
REF FAA STC: SR02024SE

PURPOSE

To add the D119-646-451/-452 Wearplate Kits for Agusta OEM skidtubes p/n 109-0570-03-109/-110. The kits consist of full length stainless steel wearplates with hardcoat welds to replace the existing OEM wearplates and provide full length wearplate coverage similar to a Dart replacement skidtube.

DART KIT	COMPATIBLE WITH AGUSTA SKIDTUBE
D119-646-451	109-0570-03-109 (LH)
D119-646-452	109-0570-03-110 (RH)

INSTALLATION

The D119-646-451/-452 Wearplate Kits should be installed as follows. Refer to Figure 1 of this service instruction for reference:

- 1) Remove skidtube from the aircraft per Aircraft Maintenance Manual.
- 2) Remove the existing OEM wearplates as applicable.
- 3) Check for corrosion and mechanical damage on the bottom of the skidtube in accordance with the Aircraft Maintenance Manual and repair as required.
- 4) Temporarily locate/clamp the D4132-041/-042 Fwd Wearplate and D4134-041/-042 Aft Wearplate on the skidtube and transfer drill Ø0.343" from the saddle to the inboard wearplate tab.
- 5) Temporarily locate/clamp the D4133-041 Mid Wearplate on the skidtube between the D4132-04X / D4134-04X wearplates. Mark and transfer drill Ø0.297" to the skidtube (32 places).
- 6) Touch up paint finish as required per the Aircraft Maintenance Manual.
- 7) Install AELS-1032-XXX inserts (32 places) in Ø0.297" holes as shown in Figure 1 of this service instruction.
- 8) Install the D4132-041/-042, D4133-041, D4134-041/-042, and qty(3) D4135-1 Wearpads as shown in Figure 1 using AN3C hardware as shown. Fasten the fwd/aft wearplates to the saddle using existing hardware. It is recommended that the fasteners are installed with Sikaflex-241/-291, Proseal 890, or MIL-S-8802 Class B2 sealant.
- 9) Seal wearplates using Sikaflex-241/-291, Proseal 890, or MIL-S-8802 Class B2 sealant as required.
- 10) Re-install modified skidtube on aircraft per Aircraft Maintenance Manual.

A	NEW ISSUE	CP	10.06.11
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE USA, INC	
DRAWN	qp	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9526	SHEET 1 OF 3
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	OEM WEARPLATE KIT	NTS
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PARTS LIST

QTY -451	QTY -452	PART NUMBER	DESCRIPTION
X		D119-646-451	WEARPLATE KIT, OEM LH
	X	D119-646-452	WEARPLATE KIT, OEM RH
1		D4132-041	WEARPLATE, FWD LH
1		*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4132-042	WEARPLATE, FWD RH
	1	*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
1	1	D4133-041	WEARPLATE, MID
1	1	*D4133-3	GASKET (BONDED WITH 3M 1300/1300L)
1		D4134-041	WEARPLATE, AFT
1		*D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4134-042	WEARPLATE, AFT
	1	.D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
3	3	D4135-1	WEARPAD
20	20	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
54	54	AN3C5A	BOLT
54	54	NAS1149CO332R	WASHER

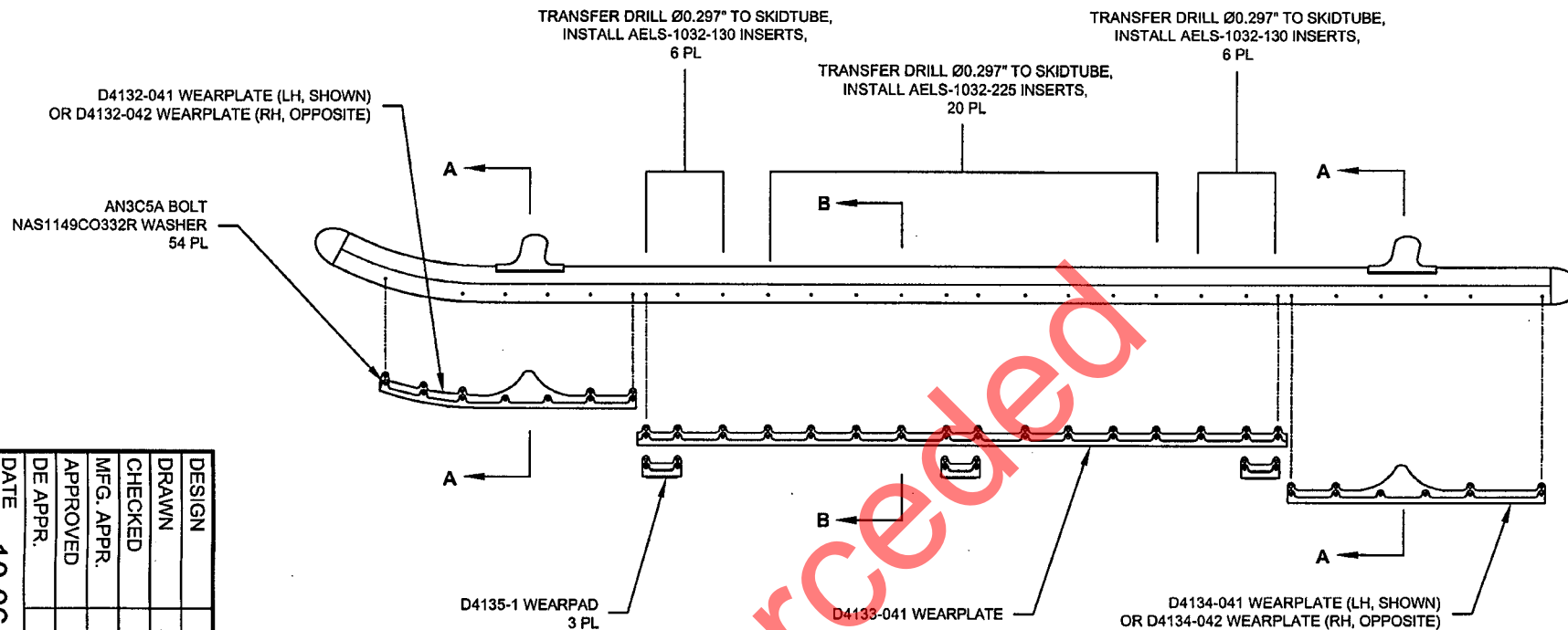
* denotes that part is included in assembly above

WEIGHT AND BALANCE

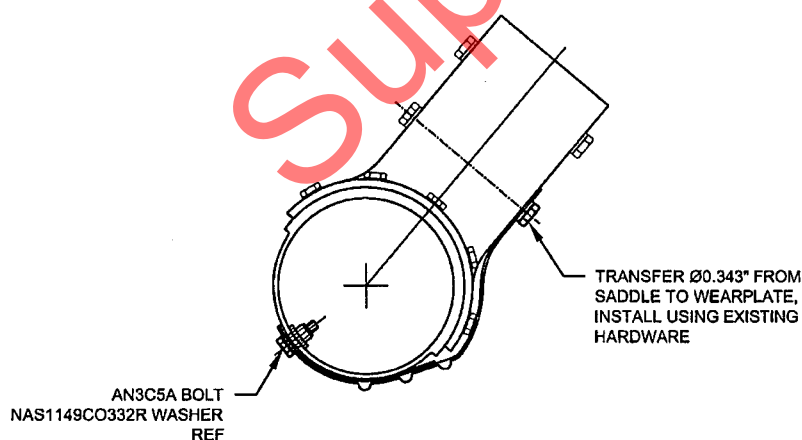
The following weight and balance information is for the Dart D119-646-451/-452 kits only. The weight and balance of the wearplates removed are the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-451 WEARPLATE KIT, LH	10.8 lb 4.9 kg	117.7 in 2.99 m	1271 in lb 14.7 m kg	-39.4 in -1.00 m	-426 in lb -4.9 m kg
D119-646-452 WEARPLATE KIT, RH	10.8 lb 4.9 kg	117.7 in 2.99 m	1271 in lb 14.7 m kg	+39.4 in +1.00 m	+426 in lb +4.9 m kg

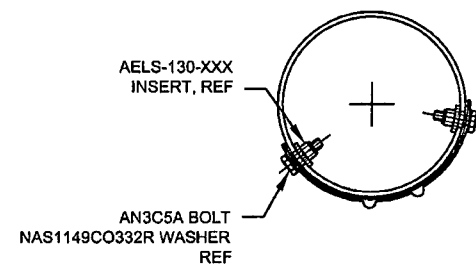
DESIGN	92	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	92		
CHECKED	HA	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9526	SHEET 2 OF 3
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	OEM WEARPLATE KIT	NTS
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**FIGURE 1: D119-646-451 WEARPLATE KIT, LH (SHOWN)
D119-646-452 WEARPLATE KIT, RH (OPPOSITE)**



**SECTION A-A:
SADDLE DETAIL**



**SECTION B-B:
TYPICAL MID SECTION**

DESIGN	DP	DART AEROSPACE USA, INC
DRAWN	DP	PORT HADLOCK, WA
CHECKED	DP	
MFG. APPR.	N/A	DRAWING NO.
APPROVED	DP	DSI 9526
DE APPR.	DP	TITLE
DATE	10.06.11	OEM WEARPLATE KIT
		REV. A
		SHEET 3 OF 3
		SCALE
		NTS

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